

Ship Dec 23

Work Order ID 139110

139110

November 13, 2015 2:02:18 PM

Page 1

Item ID: D212-725-1-012

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Angle

Stop

NS2

Start Date: 11/13/2015 Start Qty: 1.00

Required Date: 12/23/2015 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: SH

Date: 20151112

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4216

A

100

0.00

100

Small Fab

Memo

0.00

Small Fab

1-Cut as per dwg

2-Make radius as pre dwg and deburr

2 FF

DEC 09 2015

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

(2)

DAS
38
9-89

DEC 09 2015

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

2 0 15-12-9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 139110

139110

November 13, 2015 2:02:18 PM

Page 2

Item ID: D212-725-1-012

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Angle

Stop

NS2

Start Date: 11/13/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/23/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

DAS
38
9-89

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

2

38
9-89

DEC 09 2015

140

Identify as per dwg & Stock Location: S153

0.00

140

Packaging

Memo

0.00

Packaging

2

DEC 10 2015

38
9-89

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

ML5

DEC 10 2015

ML5

DEC 10 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

November 13, 2015 2:02:24 PM

Page 1

Work Order ID: 139110

139110

Parent Item: D212-725-1-012

D212-725-1-012

Parent Item Name: Angle

Start Date: 11/13/2015

Required Date: 12/23/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.10.27 as per dwg revD DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3A1.0 X 1.0 X.125		Purchased	No			100	f	0.0000	0.2125	0.223684			

M2024T3A1 0 X 1 0 X 125 X 0.188
2024-T3511 ANGLE 1" X 1" X .125" W

**

0.425 FF DEC 09 2015

M13/600

DAS
10
9-89

See attach E-mail

DAS
10
9-89

DQA: _____ Date: _____

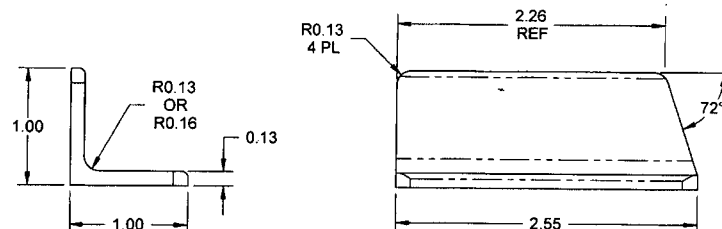
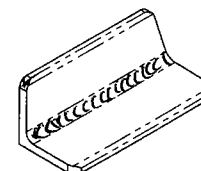


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
				OTHER :							



D212-725-1-012 ANGLE

RELEASED
2011-08-25

20151112 = 5H 139110

NOTES:

- 1) MATERIAL: 2024-T3/T3510/T3511 ALUMINUM ANGLE
PER QQ-A-200/3
OR AMS 4152, 4164 & 4165
PER DART SPEC. M2024T3A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.06 lbs

DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D4216	REV. A
MFG. APPR.		TITLE ANGLE	SHEET 2 OF 2
APPROVED			SCALE
DE APPR.			NTS
DATE	11.02.24	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

David Duval

From: David Duval
Sent: December-01-15 12:38 PM
To: Roberto Fuentes
Subject: RE: extrusion for D4216 dwg

I will attach this email to the w/o and make alex sign it. Or you good with that?

DAVID DUVAL

Production Engineering Coordinator

From: Roberto Fuentes
Sent: December-01-15 12:07 PM
To: David Duval <dduval@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Chantal Lavoie <clavoie@dartaero.com>; David Shepherd <dshepherd@dartaero.com>
Subject: RE: extrusion for D4216 dwg

David Shepherd is ok to sign a deviation to use 0.188 rad. Send him a request form if that you guys use?

Roberto

From: David Duval
Sent: December-01-15 10:01 AM
To: Roberto Fuentes <rfuentes@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Chantal Lavoie <clavoie@dartaero.com>
Subject: RE: extrusion for D4216 dwg

In stock the rad is 0.188"

DAVID DUVAL

Production Engineering Coordinator

From: Roberto Fuentes
Sent: December-01-15 12:00 PM
To: Linda Lacelle <llacelle@dartaero.com>; Chantal Lavoie <clavoie@dartaero.com>; David Duval <dduval@dartaero.com>
Subject: RE: extrusion for D4216 dwg

What is the rad you have in stock for this type extrusion?

Roberto

From: Linda Lacelle
Sent: December-01-15 9:57 AM
To: Roberto Fuentes <rfuentes@dartaero.com>; Chantal Lavoie <clavoie@dartaero.com>; David Duval <dduval@dartaero.com>
Subject: RE: extrusion for D4216 dwg

Roberto, I am not aware, but this is stock...is it the radius that is not correct???

From: Roberto Fuentes

Sent: Tuesday, December 01, 2015 11:55 AM

To: Linda Lacelle <llacelle@dartaero.com>; Chantal Lavoie <clavoie@dartaero.com>; David Duval <dduval@dartaero.com>

Subject: extrusion for D4216 dwg

Hi Linda,

David D. tell me run out of extrusion for D4216 dwg, material 2024-T31T3510/T3511 ALUMINUM ANGLE, and he tell me cannot find extrusion with this dimensions, can you tell me what are the option available closet to the dimension shown in the drawing.

Roberto